

Work Order ID 65624

January 20, 2011 11:46:04 AM



Page 1

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 1/20/11 Start Qty: 20.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3908	C								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3908

Prog Rev: SDwg Rev: C

Deburr as required

1311-1-21

(20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-1-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65624

January 20, 2011 11:46:04 AM



Page 2

Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 1/20/11 Start Qty: 20.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00



0.00 *Sulata*

QC

Memo

Quality Control

(cont)
(20)

150 Identify as per dwg & Stock Location: *90*

0.00



0.00

Packaging

Memo

Packaging

11/1/21 SL (20)

160 QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

11-01-21
MF
11-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:46:03 AM

Page 1

Work Order ID: 65624

Parent Item: D3908-1

Parent Item Name: Lug Plate, Aft Crosstube


Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	88.6003	0.0533	1.122105			

B11-21

Location	Loc Qty	Loc Code
MAT	88.6003	
114799	0.5003	
116437	24.1	
116623	64	

116437

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65624
Description: Lug Plate, Aft Crosstube		Part Number: D3908-1
Inspection Dwg: D3908	Rev: C	Page 1 of 1

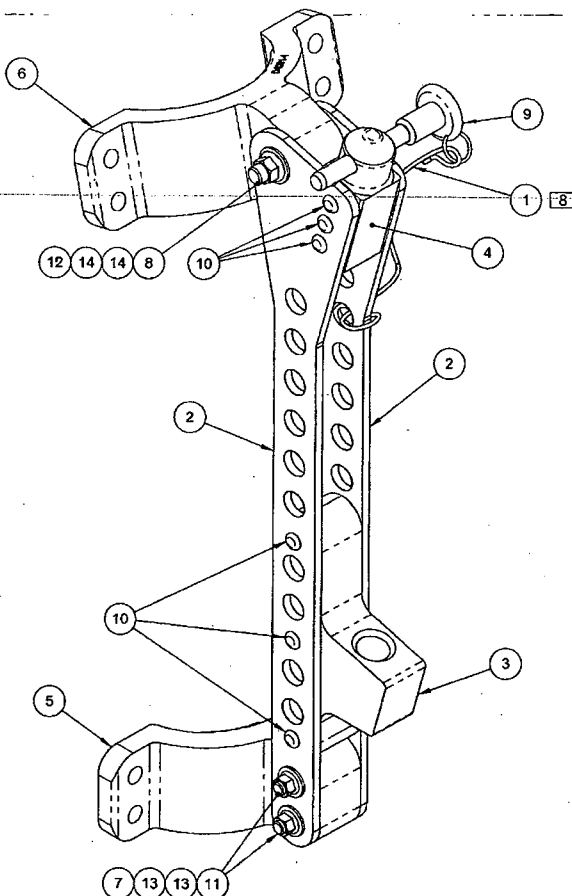
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	x		V HB02	
Ø0.191	+0.005/-0.001	.193	x		V	
Ø0.257	+0.006/-0.001	.260	x		V	
Ø0.375	+0.006/-0.001	.376	x		V	
0.310	+/-0.010	.310	x		V	
0.380	+/-0.010	.379	x		V	
0.750	+/-0.010	.748	x		V	
0.469	+/-0.010	.468	x		V	
3.25	+/-0.030	3.251	x		V	
0.65	+/-0.030	.649	x		V	
0.63	+/-0.030	.626	x		V	
1.587	+/-0.010	1.586	x		V	
1.588	+/-0.010	1.588	x		V	
5.46	+/-0.030	5.461	x		V	
3.80	+/-0.030	3.795	x		V	
2.13	+/-0.030	2.129	x		V	
1.313	+/-0.010	1.313	x		V	
0.375	+/-0.010	.373	x		V	
0.625	+/-0.010	.623	x		V	
11.15	+/-0.030	11.148	x		V PRO WS HB	
0.375	+/-0.010	.375	x		V	
0.750	+/-0.010	.753	x		V	
0.125	+/-0.010	.117	x		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-1-21	Date: 11/1/21	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	
C	10.06.07	Dimensions updated per Dwg Rev C	KJ	

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



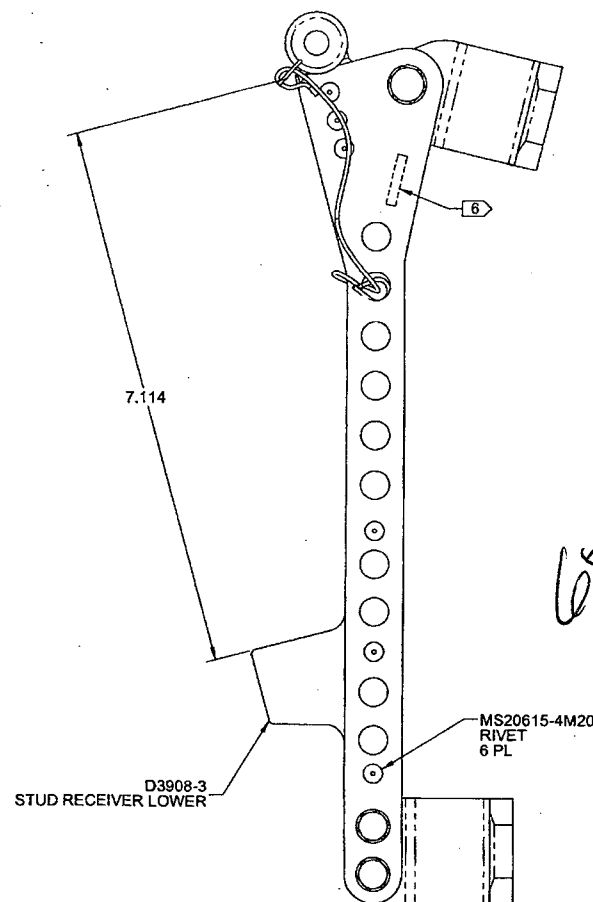
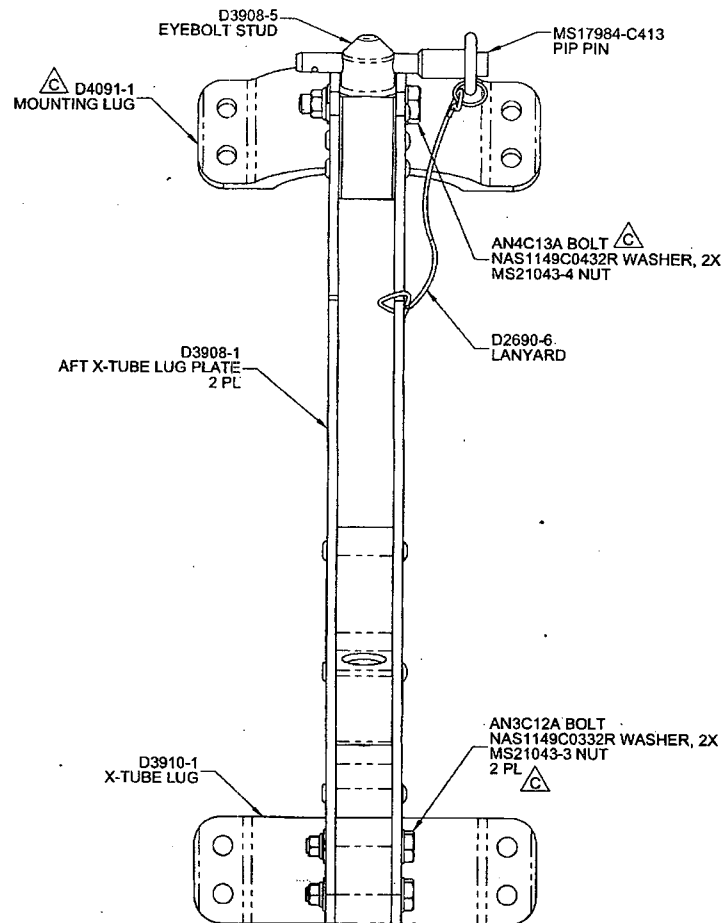
D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

RELEASED
2010-05-28
aw

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4. ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.08
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		DATE 10.05.27	
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

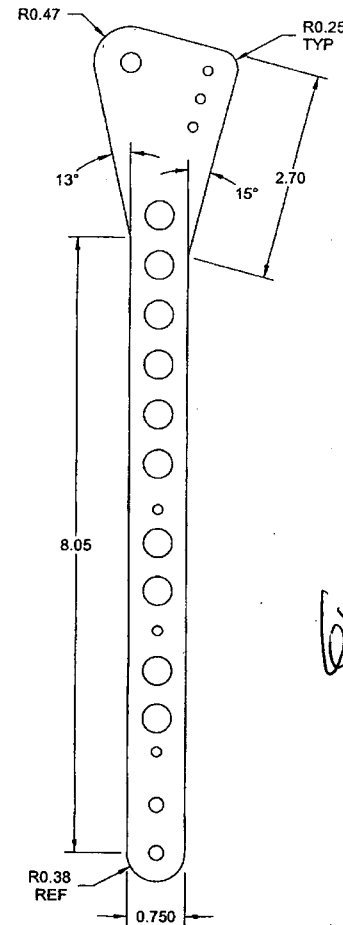
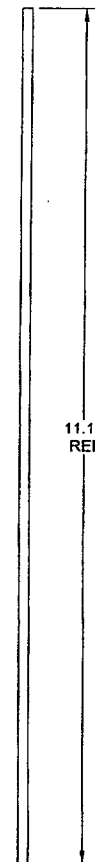
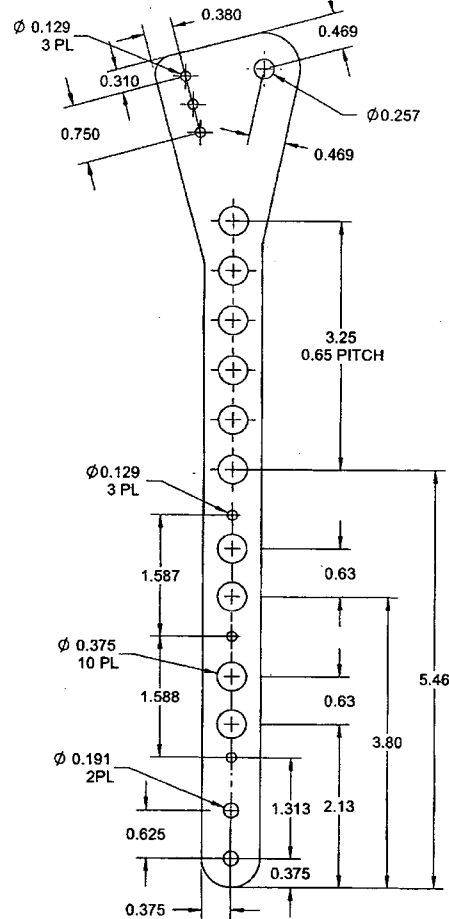


65624

RELEASED
2010-05-28
WJD

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



65624

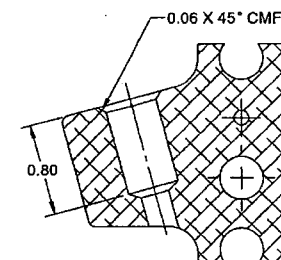
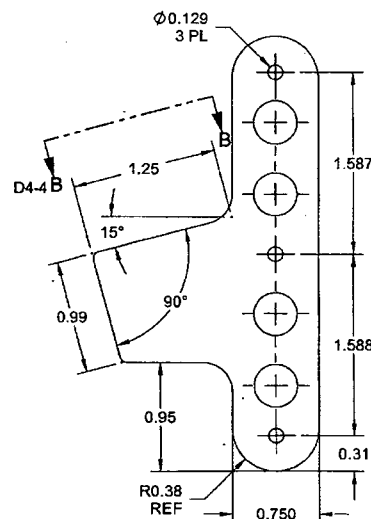
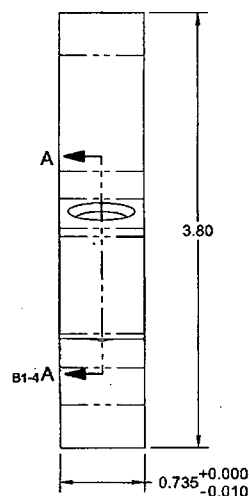
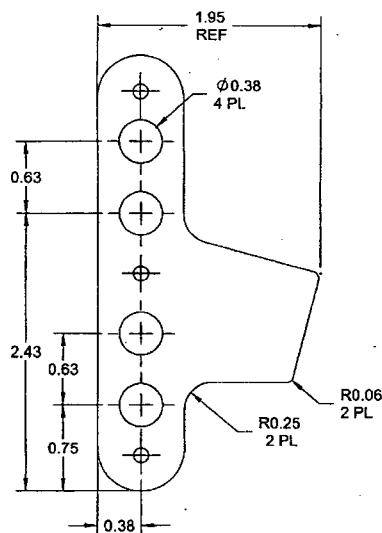
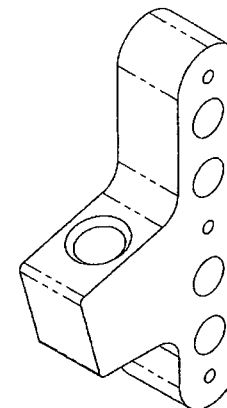
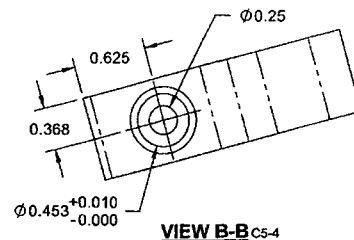
RELEASED
2010-05-28
MPO

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 LBS

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



SECTION A-A B6-4

D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

RELEASED
2010-05-28

